

5/22

8/22/05

D3109-1

PTO

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23194
<b>Description:</b> Bracket	<b>Part Number:</b>	D3209-041
<b>Dwg:</b> D3209 Rev. A	<b>Qty:</b>	<del>X</del> 12
		Page 1 of 1

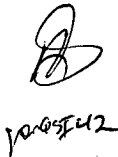
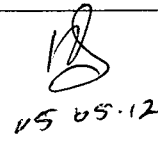

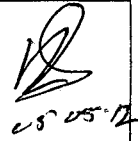


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	AB	05/05/09	4
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) <b>Identify for D3209-1</b> .143-5108 Batch: <u>M17037</u>	BG	05/05/11	12 +1
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 <b>Identify as D3209-1</b>	BG	05/05/12	12
4	QC2	Inspect parts as they come off the CNC machine	BG	05/05/12	12
5	MV	Deburr and Tumble	BG	05/05/12	12
6	QC8	Second check	EG	05-05-12	12
7	FP	Chemical conversion Coat as per QSI 005 4.1	MM	05 05 18	12
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <b>Note: Cover the hole for D3209-1 before powder coat.</b>	MM	05 05 18	12
9	QC3	Inspect Powder Coat	2	05-07-06	12
10	GA	Press fit bushing into the bracket as per Dwg D3209 <b>Pick: Packing Kit</b> Qty Part Number Description Batch 1 D3209-3 Bushing <u>B23204</u>	SD GAD	05/07/12	12
11	QC5	Inspect work to Step 10	2	05-07-13	12
12	ST	Identify and Stock	CL	05/07/13	12
13	AC	Cost / part: <u>37.75</u>	SP	05/07/15	11
14	DC	Close W/O <u>39.21</u> Inspect Level 21	SP	05/07/14	12

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	RF

RELEASED

04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23194		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/12	3	Tab undersize (.180") Program error		Destroy + Replace Folio has been changed.	BG 05/05/12			
05-07-13	3 11	wrong part # engraved onto parts. D3109-1 when should be D3209-1. program error noticed after powder coat & bushing pressed in.		Parts acceptable this time, And will be clearly identified in stock. Program error was already been changed. Identify Part # D3209-1 with line point sharpie, to correct from D3109-1	2 05-07-13	2 05-07-13		2 05-07-13

Part No: D3209-011 PAR #: \_\_\_\_\_ Fault Category: Engineering / Programming NCR: Yes No DQA: Yes Date: 05/07/14

NOTE: Date & initial all entries

QA: N/C Closed: Yes

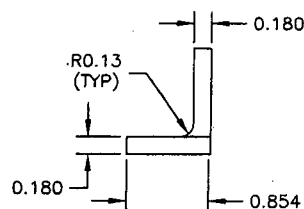
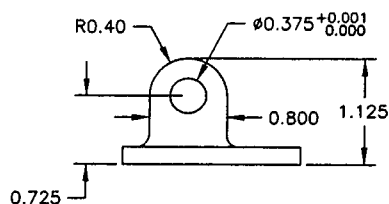
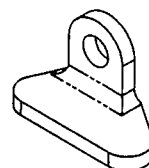
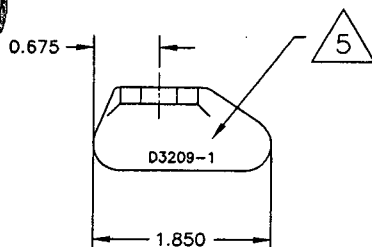
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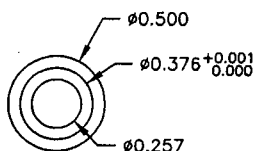
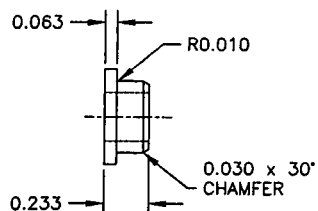
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05 H

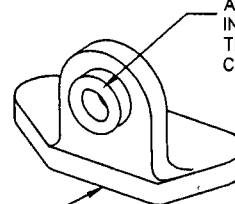


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**D3209-1 BRACKET**



D3209-3 BUSHING  
PRESS FIT, HEAD  
AT THIS FACE  
INSTALL AFTER  
THE CONVERSION  
COAT



D3209-1

4

**D3209-041 ASSEMBLY**

3

**D3209-3 BUSHING  
SCALE 1:2**

**D3209-1 BRACKET: D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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WORK ORDER

NO. 23/94

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 06, 2005  
09:55 am

Work Order No : 0023194  
Project Name : D3209-041  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3209-041  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 05-05-05  
Est Finish Date : 05-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00